



Line-up knives

	Planer knife	Corrugated back knife
L	≤ 635	≤ 635
W x T	30, 35 x 3	35, 40, 45, 50 x 4 35, 40, 45, 50 x 5 35, 40, 45, 50, 60 x 6 40, 45, 50, 60, 70 x 8

(mm)

Accessories

	Size	Code #
Special joint stone ! Darkening is possible, but it's no problem for use.	20x60x15 12x32	
 OK		
Stellite tool rest	For Rondamat	
		

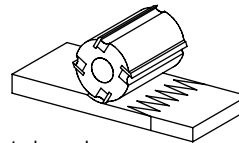
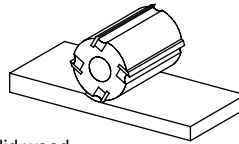
900-ST1-0

Applicable uses

Applicable



- Solid wood

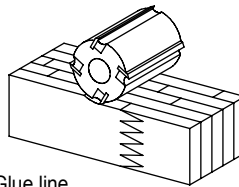


- Jointed wood

Inapplicable



- Glue line
- Wood board
(Particleboard, MDF etc.)



- Metals
- Plastics

KANEFUSA

USER GUIDE to ST-1

Kanefusa Corporation

- HEADOFFICE (Japan)
TEL: +81-587-95-7221
FAX: +81-587-95-7226
<http://www.kanefusa.co.jp/>



- KANEFUSA EUROPE B.V. (Netherlands)
TEL: +31-40-2900901
FAX: +31-40-2900908

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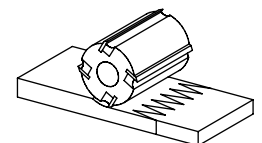
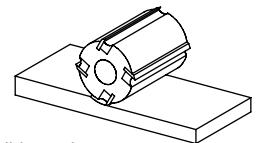
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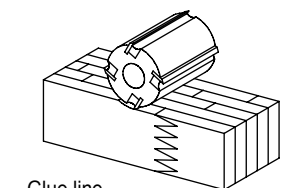


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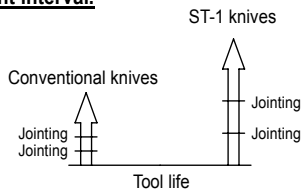
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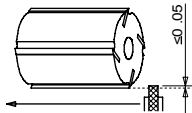
900-ST1-0

Jointing

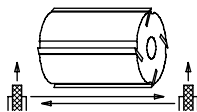
- A Kanefusa original stone is recommended.
- Monitor the surface of the workpiece during the first use of ST-1 knives and **set a new and longer joint interval.**



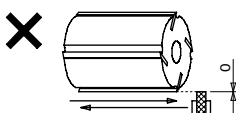
- Infeeding of each jointing is 0.05mm or less.



- Infeeding on 2 sides is preferable.

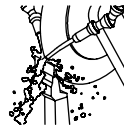


- Do not slide a stone without infeeding.

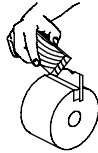


Resharpener

- **Sufficient coolant supply is essential.**

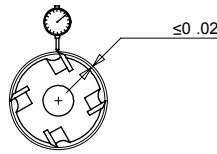


- Jointing requires a Hydro head. Knives must also be resharpened set in the Hydro head.



- Use hard woods or plastics to remove the wire edge. **Never use stones, wire brushes or metals.**

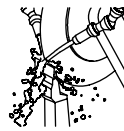
- **The concentricity must be ≤ 0.02 mm.**



- A stellite tool rest is recommended.
- Do not lap without infeeding.

Resharpener

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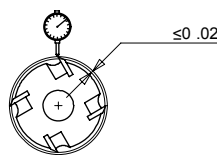


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	Type 1	Type 2	Type 3
Rough grinding			
Lapping			

Recommended grinding parameter

	Wheel specification	Infeed	Feed speed
Rough grinding	Alumina [Al ₂ O ₃] 60 - 80 (FEPA) Vitrified or resinoid	Type 1,2 ≤ 0.01 mm	Type 1,2 ≤ 20 m/min.
	Borazon [CBN] D91 - D107 (FEPA) 75 (conc.) Vitrified	Type 3 ≤ 0.02 mm	Type 3 2-10m/min.
Lapping	Silicon carbide [SiC] 800 (FEPA) Resinoid	≤ 0.01 mm	≤ 10 m/min.

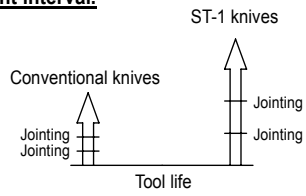
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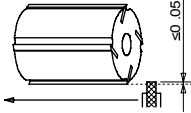
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Jointing

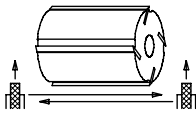
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